

Date: Wednesday, 09/07/2008 8:04:48 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BUSHING		
Job Number	: 40390					
Estimate Number	: 10823					
P.O. Number	:			Part Number	: D23271	
This Issue	: 09/07/2008	S.O. No. :		Drawing Number	: D2327 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	: 40084			Drawing Revision	: D	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08. 7.09</u>			Due Date	: 16/07/2008	
Comment	: Est. D 05.11.02 Removed 303 SS KJ/EC			Qty:	50	
	Est Rev:E Removed 303SS JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0375	304 SS ROUND BAR	
		Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s)	
		Inventory	
		Material: AISI 304 Round Bar Ø0.375"	
		(M304R0.375) Batch: <u>M1086026</u>	<u>J.F. 08/07/17 (50)</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL	
		Turn per Folio FA232 and Dwg D2327	
		Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>J.F. 08/07/17 (50)</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>8/08/07/18 (50)</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Identify and Stock	
		Location: <u>26</u>	<u>8/7/18</u>
			<u>Sq</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 09/07/2008 8:04:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 40390

Part Number: D23271

Job Number:



Seq. #:	Machine Or Operation:	Description:
6.0	QC21	FINAL INSPECTION/W/O RELEASE



08/07/21 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.07.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40390
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>J.F.</u>	Audited by: <u>S.L.</u>	Prototype Approval: N/A
Date: <u>08/07/17</u>	Date: <u>08/07/17</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.02.01	Tolerance revised for Ø0.375	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

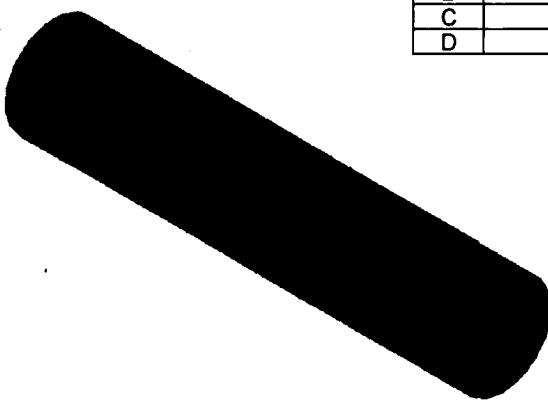
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED CH	DRAWING NO. D2327
DATE 06.10.12		TITLE SPACER BUSHING

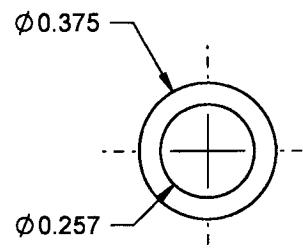
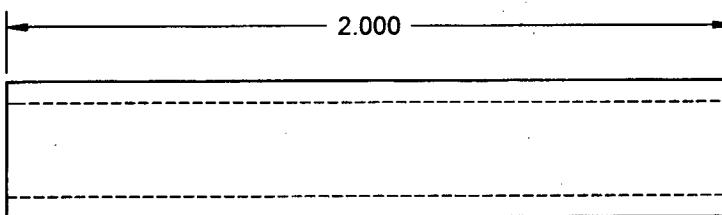
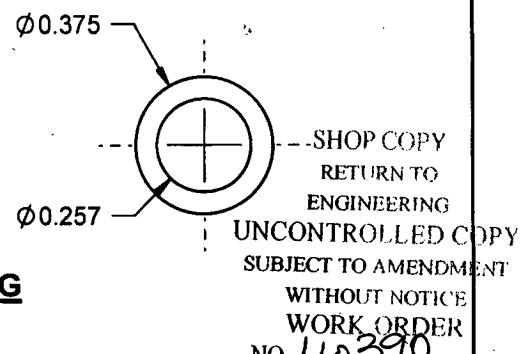
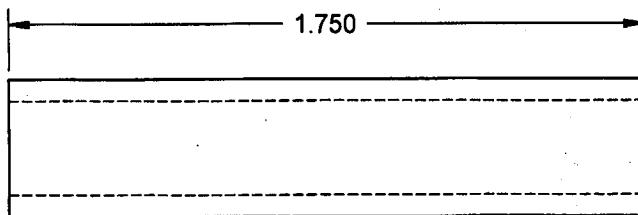
REV. D
SHEET 1 OF 1
SCALE
2:1

REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL



RELEASED

06.11.14

**D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

**COPYRIGHT © 1994 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries